

## Classifications

DIN 8555	EN 14700
E 6-UM-60	E Fe8

## Characteristics and field of use

UTP DUR 650 Kb is suitable for cladding structural parts subject to abrasion combined with impact. The main applications are tools in the earth moving industry and crushing plants as well as cold and hot working tools. The deposit is only machinable by grinding.

UTP DUR 650 Kb is a martensitic alloy. The stick electrode is suited in impact an pressure stress situations. Machining of the weld metal only by grinding.

Hardness of the pure weld deposit 58 – 60 HRC  
 1 layer on high Mn-steel approx. 24 HRC  
 2 layers on high Mn-steel approx. 45 HRC

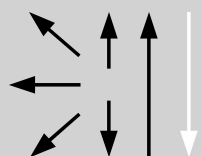
## Typical analysis in %

C	Si	Mn	Cr	Mo	Nb	Fe
0,5	0,8	1,3	7,0	1,3	0,5	balance

## Welding instruction

Hold stick electrode as vertically as possible, keep a short arc. Preheating of non-alloyed steels is not necessary. Preheat heavy parts and high-tensile base materials to 250 – 350° C. If more than 3 – 4 layers are needed, apply the softer stick electrodes UTP DUR 250 or UTP DUR 300 for buildup. On high Mn-steel, UTP BMC should be used. Redry stick electrodes that have got damp for 2 h / 300° C.

## Welding positions



Current type DC (+) / AC

## Recommended welding parameters

Electrodes Ø x L [mm]	3,2 x 450	4,0 x 450	5,0 x 450	6,0 x 450*
Amperage [A]	80 – 110	130 – 170	160 – 200	190 – 230

\*available on request